

Date: Monday, 02/02/2009 3:47:07 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BASKET LID ASSY (A119)
Job Number : 45426A	
Estimate Number : 12445	
P.O. Number :	Part Number : D3515041
This Issue : 02/02/2009 S.O. No. :	Drawing Number : D3515 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 45425A	Material :
Written By :	Due Date : 15/03/2009 Qty: 1 Um: Each
Checked & Approved By : <u>JUD 09.02.03</u>	
Comment : EST rev. A 06.06.05 Preliminary EC est B 07.04.09 revA dwg EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D22321	Basket Hinge
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Basket Hinge Batch: <u>B39454</u> → 2x <u>JS 09/02/09</u>		
2.0	D31663	Basket Hoop
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Basket Hoop Batch: <u>B44057</u> B44997 <u>JS 09/02/09</u>		
3.0	D23271	Spacer Bushing
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Spacer Bushing Batch: <u>B40390</u> → 2x <u>JS 09/02/09</u>		
4.0	D2506	Label Plate
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Placard Batch: <u>B39457</u> → 1x <u>JS 09/02/10</u>		
5.0	D2581	Mounting Bracket
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Mounting Bracket Batch: <u>B43800</u> → 2x <u>JS 09/02/09</u>		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

M304TS0750W065

304 SQ Tube .75x.75x.065W

✓



Comment: Qty.: 43.5750 f(s)/Unit Total: 43.5750 f(s)

AISI 304 SQ Tube.75x.75x.065W

Batch: M110561

SAD 09-02-09 ①

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut rib D3515-1 (2) as per dwg D3516

SAD 09-02-09

2-Cut rib D3515-3 (2) as per dwg D3516

SAD 09-02-09

3-Cut rib D3515-5 (6) as per dwg D3516

SAD 09-02-09

4-Cut rib D3515-7 (3) as per dwg D3516

SAD 09-02-09

5-Cut Rib (4) D2236 from D3166-3 per dwg D2236

SAD 09-02-09 ①

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3515

LY 09/02/10

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-02-12

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 09-02-12

11.0

M304EX07516F

Expanded Metal Flat SS

✓



Comment: Qty.: 21.0000 sf(s)/Unit Total: 21.0000 sf(s)

Expanded Metal Flat Stainless steel

Batch: M110292

SAD 09-02-09 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D3515041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut expanded metal for base as per dwg D3516 ✓

2-Cut expanded metal for base ends as per dwg D3516 ✓

3-Weld expanded metal to base as per dwg D3516 ✓

Handwritten: 09/02/10 (1X)

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Handwritten: PD 09-02-12

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: PD 09-02-12

15.0

POWDER COATING

POWDER COATING



Handwritten: M1109996



Handwritten: (1X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

1ST COAST:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

***** 2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

Handwritten:
3:30
4:00 F
4:00
4:20
4:00 F
4:50

Handwritten: M. 09/02/13

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: Fd 09/02/17 (1)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D3515 and QSI 005 4.4 and spray paint as per dwg

wing walk: M110454

black spray paint: M110211

Handwritten: Fd 09/02/17 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D3515041

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W645426

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/26

Job Completion



MF
09-02-26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



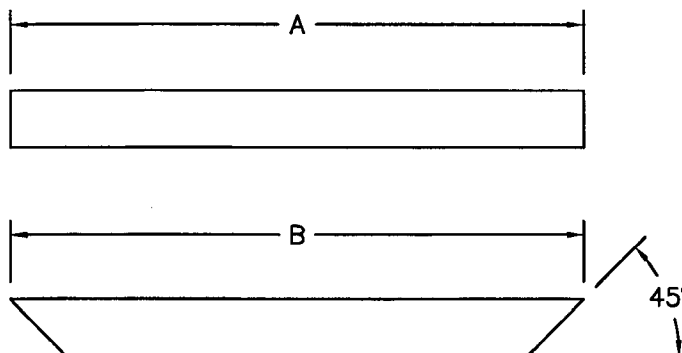
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3515	REV. A SHEET 1 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)	SCALE NTS
A	06.05.05	NEW ISSUE	

RELEASED

06.11.17 *[Signature]*

PARTS LIST FOR D3515-041 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH	LENGTH	DESCRIPTION
		A	B	
D3515-1	2	—	25.50	RIB
D3515-3	2	—	101.30	RIB
D3515-5	6	33.84	—	RIB
D3515-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



D3515-1/-3/-5/-7

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
(REF. DART SPECS. M304TS0.750W.065)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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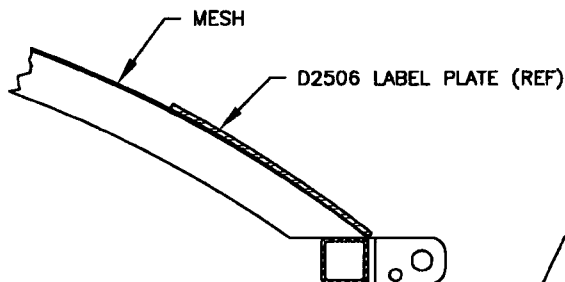
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DART

RELEASED

06.11.17



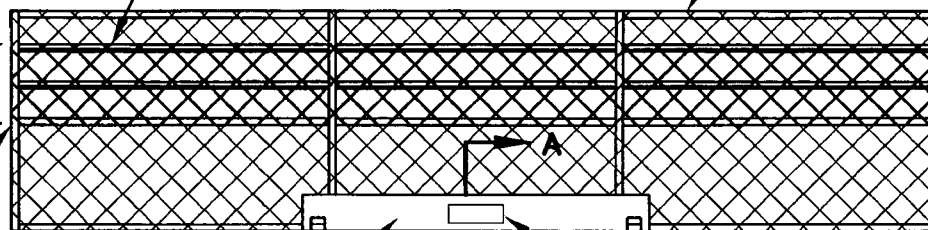
SECTION A-A (ROTATED 90° CCW)

FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT

TACK WELD MESH TO
FRAME AT EVERY AVAILABLE
LOCATION IN AREA TO BE
ANTI SKIDDED

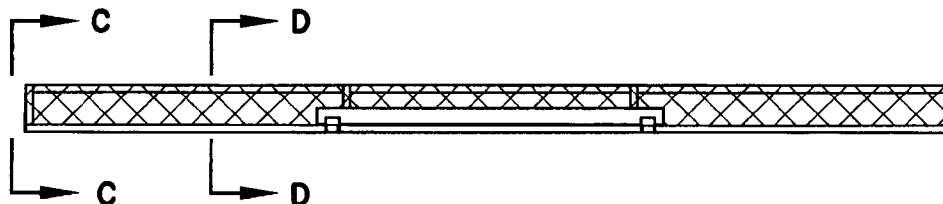
SKIN OUTSIDE SURFACE OF LID WITH
3/4-16F EXPANDED SS. TACK WELD
EACH END STRAND TO FRAME

SEE DETAIL B FOR
FRAME ASSEMBLY



D2506 LABEL PLATE
CENTER ON THE BASKET

REMOVE 2" X 6" SECTION
OF MESH FROM BEHIND
LABEL PLATE



D3515-041 BASKET LID ASSEMBLY

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF. DART SPEC. M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) SPRAY PAINT BLACK INSIDE SURFACE
- 5) APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

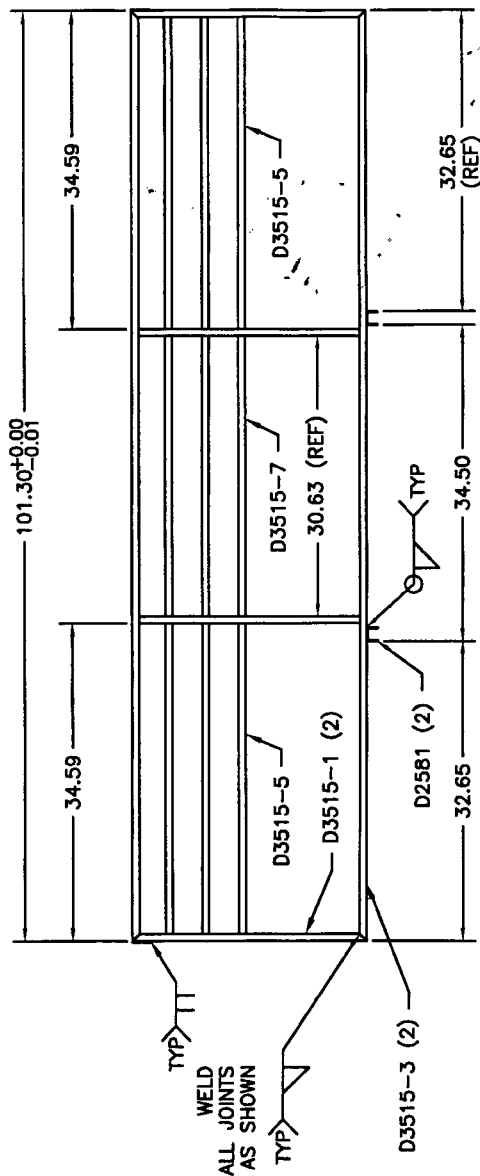
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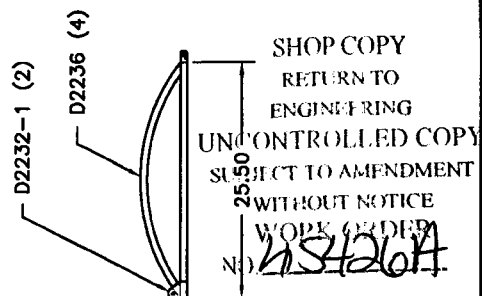
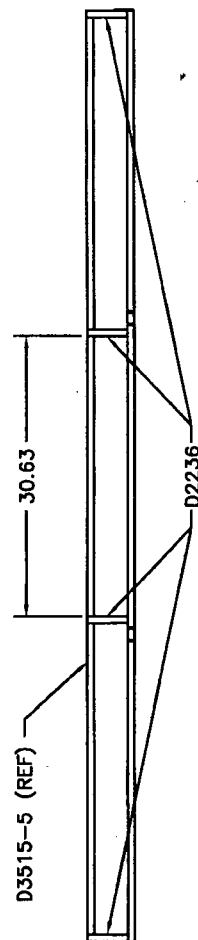
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CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. A
06.05.05	BASKET LID ASSEMBLY (A119)	SHEET 2 OF 4
		SCALE 1:20



DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3515	REV. A SHEET 3 OF 4
DATE 06.05.05	TITLE BASKET LID ASSEMBLY (A119)		SCALE 1:20



DETAIL B
FRAMEWORK SHOWN FOR CLARITY
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES



RELEASED

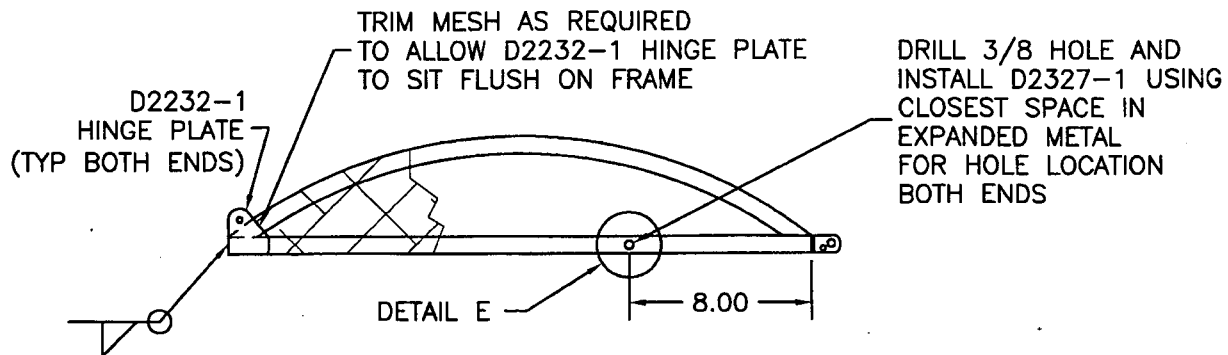
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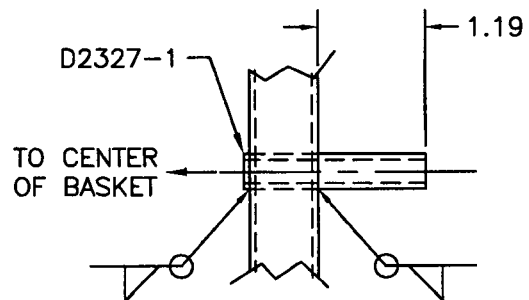
DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3515	REV. A SHEET 4 OF 4
DATE 06.05.05	TITLE BASKET LID ASSEMBLY (A119)		SCALE 1:8



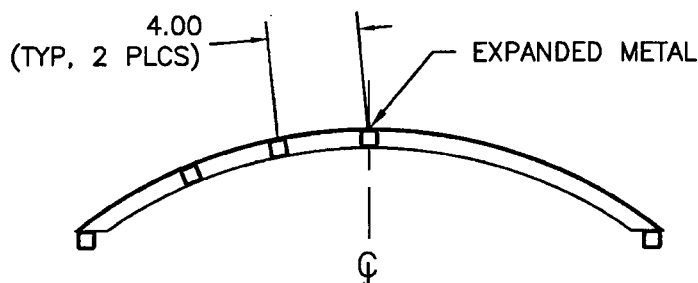
SECTION C-C SIMILAR BOTH END RIBS

RELEASED

06-11-17 H



DETAIL E



SECTION D-D SAME BOTH CENTER RIBS

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